

Date: Tuesday, 11/14/2006 10:13:27 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 29449	
Estimate Number : 12589	
P.O. Number : <i>N/A</i>	Part Number : D35603
This Issue : 11/14/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3560 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : _____	Due Date : 11/25/2006 Qty: 5 Um: Each
Checked & Approved By : <i>[Signature]</i> 06 11 14	
Comment : Est Rev:A New Issue 06-11-10 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
-----	--------------------	-------------------------



Comment: Qty.: 1.0080 f(s)/Unit Total: 5.0400 f(s)

6061-T6 Bar .50" x 6.0"

Batch: *M101919 ml 06 11 20*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3560

Dwg Rev: *A*

Prog Rev: *A*

*ml 06 11 21*

*(5)*

2-Deburr if necessary

Note: .507" Dia & .196" Dia Holes are to opened on manual mill after Waterjet

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



*(5)*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

1-Open .196" Dia hole

2-C'Bore as per Dwg D3560.

3-Ream .507" as per Dwg D3560

\*\*\*Ensure to C'Bore on Corect side\*\*\*

*J.F. 06/12/19*

*(5)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 06/12/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 11/14/2006 10:13:27 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 29449

Part Number: D35603

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/12/19 (5)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/21/9x5

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

06/12/20 (5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/20 (5)

Job Completion



C Loc 11/21/20

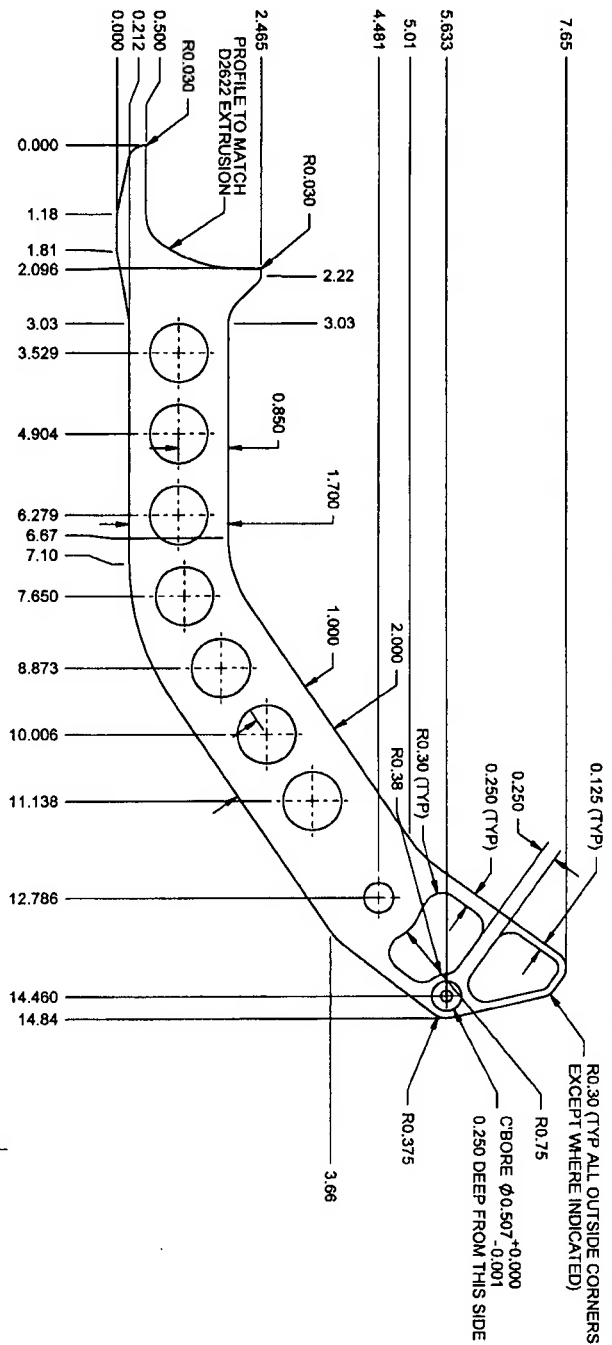
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

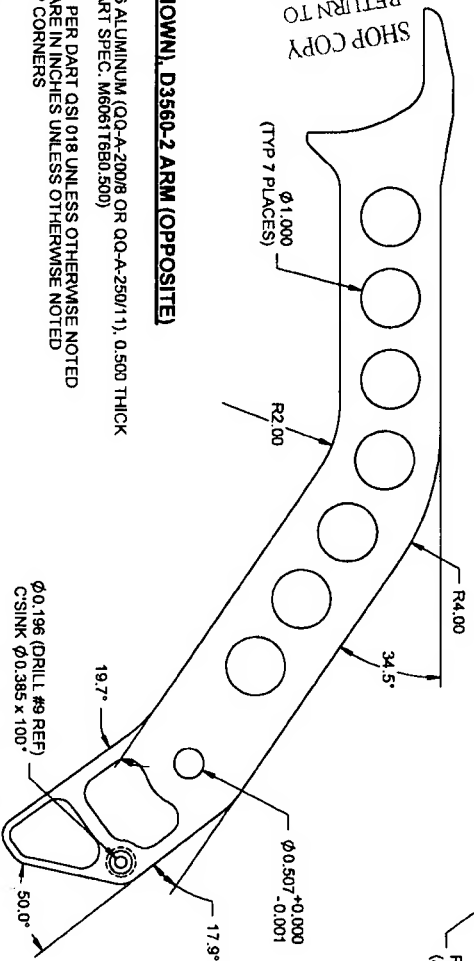
NOTE: Date & initial all entries



WORK ORDER NO. 294479  
 WITHOUT NOTICE  
 SUBJECT TO AMENDMENT  
 ENGINEERING  
 RETURN TO  
 SHOP COPY

# D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

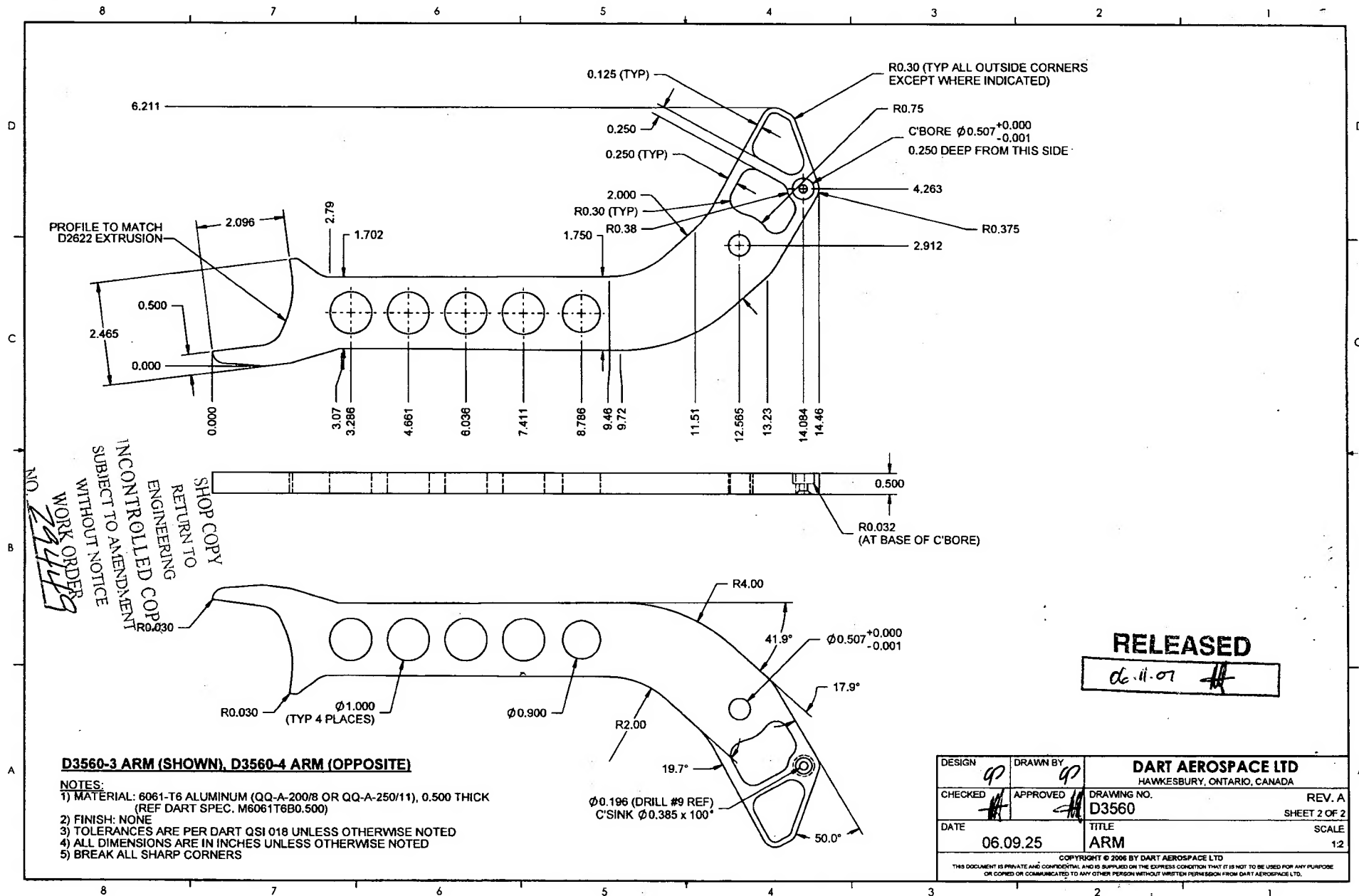
- NOTES:
- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/1), 0.500 THICK (REF. DART SPEC. M6061T6B0.500)
  - 2) FINISH: NONE
  - 3) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP CORNERS



A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY <i>q</i>	DART AEROSPACE LTD
CHECKED	APPROVED <i>q</i>	HAWESBURY, ONTARIO, CANADA
DATE	06.09.25	D3560
		SHEET 1 OF 2
		SCALE 1:2
		ARM

THIS DOCUMENT IS PRIVATE AND IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

RELEASED  
 06.11.07



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 29449
<b>Description:</b> ARM		<b>Part Number:</b> D3560-3
<b>Inspection Dwg:</b> D3560-1 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000 - 0.001	0.506	✓		VERN	
Ø0.196	+0.005 - 0.001	0.196	✓		VERN	
Ø0.900	+0.010 - 0.001	0.900	✓		VERN	
Ø1.000	+0.010 - 0.001	1.000	✓		VERN	
1.750	+/- 0.010	1.751	✓		VERN	
1.702	+/- 0.010	1.705	✓		VERN	
2.465	+/- 0.010	2.464	✓		VERN	
2.000	+/- 0.010	2.003	✓		VERN	
0.250	+/- 0.010	0.253	✓		VERN	
0.250	+/- 0.010	0.253	✓		VERN	
0.125	+/- 0.010	0.128	✓		VERN	
0.500	+/- 0.010	0.500	✓		VERN	
385x100°	± .010"	385x100°	✓			
507x250 deep	± .010"	250"	✓			

<b>Measured by:</b> M. M. S.	<b>Audited by:</b> En	<b>Prototype Approval:</b> N/A
<b>Date:</b> 06/11/21	<b>Date:</b> 06/12/19	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	